

Date: Monday, 19/01/2009 9:12:49 AM
 User: Linda Lacelle

Process Sheet

Customer : CC-DAR01 Dart Aerospace Ltd.

Job Number : 44882

Estimate Number : 10804

P.O. Number :

This Issue : 19/01/2009 S.O. No. :

Prsht Rev. : NC

First Issue : / / Type : CROSSTUBES

Previous Run : 00015

Written By : Checked & Approved By : 

Comment :

Drawing Name : D206-667-103

Part Number : D206667103

Drawing Number : REWORK-HAI

Project Number :

Drawing Revision :

Material :

Due Date : 26/01/2009 Qty: 1 Um: Each

Additional Product

Job Number:



DART		TEL: 1-613-632-3336	
TRANSPORT CANADA APPROVAL #09-39		FAX: 1-613-632-4443	
PN	D206-667-103	CHG	CHG002
DESC	Crosstube Fwd High	SIC	SH01-5
LOT	B36377	SIC	SR01304NY
MODEL	Bel 206L/L1/L3/L4	SIC	
MADE IN CANADA			

Seq. #: Machine Or Operation:

Description :

1.0 CROSSTUBES

CROSSTUBES RESOURCE 1



Comment: CROSSTUBES RESOURCE 1

PULL FROM 2008 HAI

1 X D206-667-103 B36377 CHG002 ml 09 01 19 (1)

2.0 D206667103

Crosstube Fwd



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
 Crosstube Fwd ml 09 01 19 (1)

3.0 CROSSTUBES

CROSSTUBES RESOURCE 1



Comment: CROSSTUBES RESOURCE 1

REMOVE SUPPORTS, RE-INSTALL WITH Rubber Cushion: 42998
 MAGNABOND PER CHG004 B109900 clamps: 109269 ml 09 01 21 (1)

4.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

5.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Date: Monday, 19/01/2009 9:12:49 AM
User: Linda Lacelle

Process Sheet

Customer: CC-DAR01 Dart Aerospace Ltd.

Drawing Name: D206-667-103

Job Number: 44882

Part Number: D206667103

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

AN532A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Bolt

Batch: M110363

7.0

MS21042L5

Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Nut

Batch: M109297

8.0

AN57A

Bolt



Comment: Qty.: 10.0000 Each(s)/Unit Total : 10.0000 Each(s)

Pick:Packing Kit

Qty Part number

Description Batch

10 AN5-7A

Bolt

M109952 2P

M110363 8X

9.0

AN530A

BOLT



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:Packing Kit

Qty Part number

Description Batch

4 AN5-30A

Bolt

M109061

10.0

AN960JD516

Washer



Comment: Qty.: 18.0000 Each(s)/Unit Total : 18.0000 Each(s)

Pick:Packing Kit

Qty Part number

Description Batch

18 AN960JD516

Washer

M109752

11.0

AN9704

Washer



Comment: Qty.: 12.0000 Each(s)/Unit Total : 12.0000 Each(s)

Washer

batch: M110399

LC 9/01/22

Date: Monday, 19/01/2009 9:12:49 AM
User: Linda Lacelle

Process Sheet

Customer: CC-DAR01 Dart Aerospace Ltd.

Drawing Name: D206-667-103

Job Number: 44882

Part Number: D206667103

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

S 09/01/22 @

13.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

REPACKAGE PER PPP

USING NEW B/N

NEW LABELS AND PAPERWORK REQ'D

Rev C 9/1/22

4519439 Rev A

CHK 004

JP

per ECN 02-593

(K)

SP

14.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/01/26 J

Job Completion



MF 09-01-23

Date: Wednesday, 21/01/2009 3:09:51 PM
User: Julie Dawson

Process Sheet

Customer: CC-DAR01 Dart Aerospace Ltd.

Drawing Name: D206-667-103

Job Number: 44882

Part Number: D206667103

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

13.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

REPACKAGE PER PPP

USING NEW B/N

NEW LABELS AND PAPERWORK REQ'D

CH0004

DSI 9439.

JUD 09.01.22

14.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



Date: Wednesday, 21/01/2009 10:06:59 AM
 User: Julie Dawson

Process Sheet

Customer	: CC-DAR01 Dart Aerospace Ltd.	Drawing Name	: D206-667-103
Job Number	: 44882		
Estimate Number	: 10804		
P.O. Number	:	Part Number	: D206667103
This Issue	: 21/01/2009	S.O. No.	:
Prsht Rev.	: NC	Drawing Number	: REWORK-HAI
First Issue	: 19/01/2009	Project Number	:
Previous Run	: 00015	Drawing Revision	:
		Material	:
Written By	:	Due Date	: 26/01/2009
Checked & Approved By	:	Qty:	1 Um: Each
Comment	:		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	CROSSTUBES	CROSSTUBES RESOURCE 1
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Comment: CROSSTUBES RESOURCE 1

PULL FROM 2008 HAI
 1 X D206-667-103 B36377

REFERENCE ONLY

ECW 08-593 Added
 On step 11. already
 JUD
 09.01.21

2.0	D206667103	Crosstube Fwd
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
 Crosstube Fwd

3.0	CROSSTUBES	CROSSTUBES RESOURCE 1
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Comment: CROSSTUBES RESOURCE 1

REMOVE SUPPORTS, RE-INSTALL WITH
 MAGNABOND PER CHG004

Job Completion



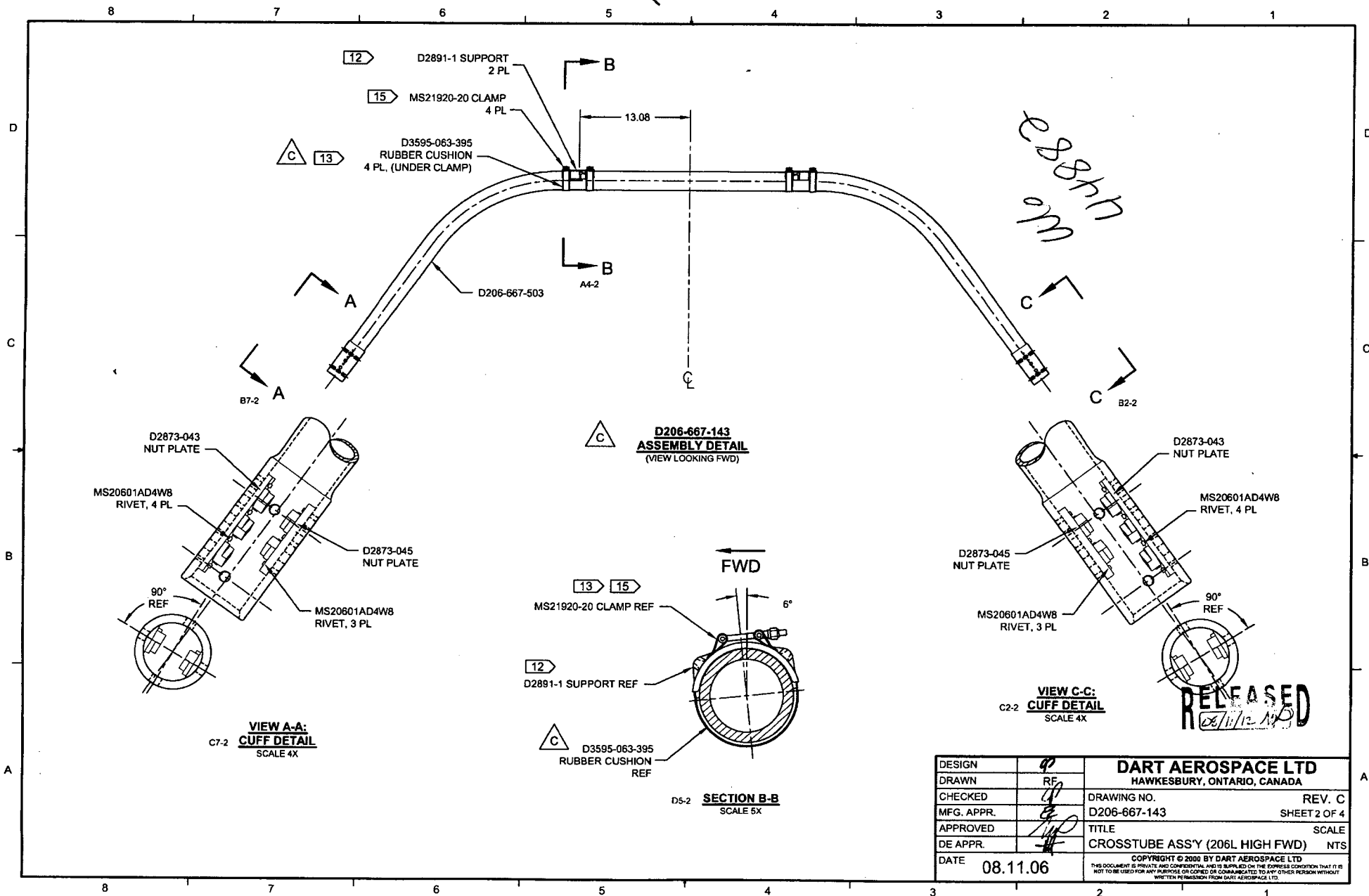
Item	Qty -143	Part Number	Description
1	X	D206-667-143	CROSSTUBE ASSEMBLY (206L HIGH FWD)
2	1	D6002-115	CROSSTUBE
3	2	D2873-043	NUT PLATE
4	2	D2873-045	NUT PLATE
5	2	D2891-1	SUPPORT
6	4	D3595-063-395	RUBBER CUSHION
7	4	MS21920-20	CLAMP (OR MS21920-21)
8	14	MS20601AD4W8	RIVET (OR NAS9302B-4-8)
9	A/R	MAGNOBOND 6398	ROCKWELL SPECIFICATION RBO-120-023 ADHESIVE (TEXTRON/BELL SPEC. 299-947-100, TYPE II, CLASS 2 ADHESIVE)

GENERAL NOTES:

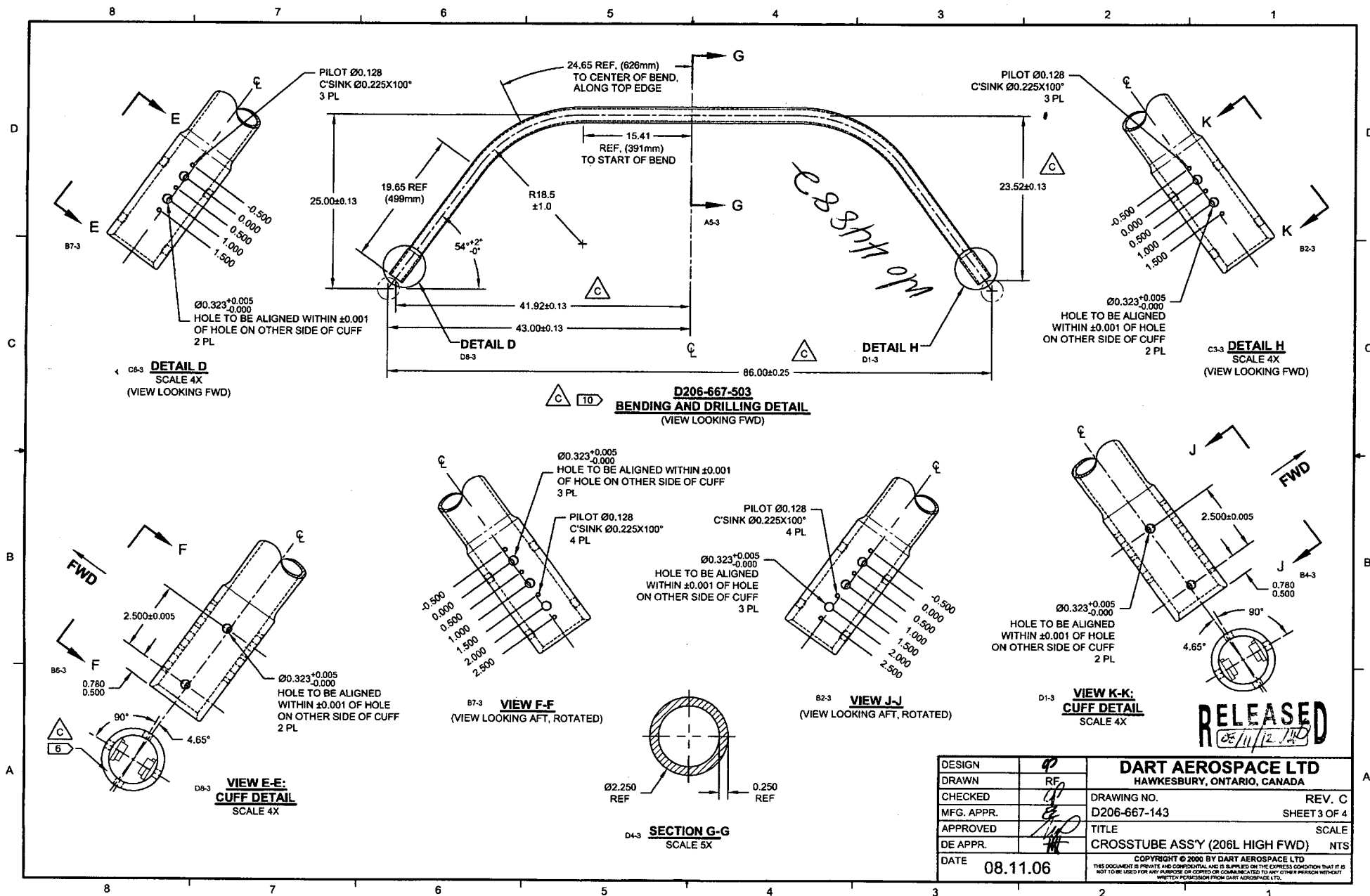
- 1) MATERIAL: MANUFACTURED FROM D6002-115
FINISHED LENGTH = 104.98±0.020
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2
PAINT OUTSIDE PER DART QSI 005 4.2
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED.
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX.
- 6) IDENTIFICATION: SCRIBE DART PART NUMBER "D206-667-143" AND BATCH NUMBER ON INSIDE OF CUFF USING VIBRATING STYLUS.
- 7) WEIGHT: 15.5 lbs
- 8) PART IS SYMMETRIC ABOUT CENTERLINE.
- 9) RUN CUTTER OFF PART WHERE INDICATED. BLEND OUT EDGE LONGITUDINALLY. TRANSITION SHOULD BE SMOOTH.
- 10) BEND PROGRESSIVELY WITH A MINIMUM OF 10 PASSES. MAXIMUM TUBE FLATTENING DUE TO BENDING IS 6% BASED ON O.D.
- 11) LIQUID PENETRANT INSPECT OUTSIDE SURFACE OF CROSSTUBE PER QSI 038.
- 12) INSTALL D2891-1 SUPPORT USING 0.03" TO 0.06" THICK LAYER OF MAGNOBOND 6398 PER QSI 015. LET CURE FOR 12 HOURS AFTER INSTALLATION AND PRIOR TO PACKAGING.
- 13) INSTALL MS21920-20 CLAMPS (OR -21) WITH D3595-063-395 RUBBER CUSHIONS TO SECURE THE D2891-1 SUPPORT ON TOP SIDE OF THE CROSSTUBE. ENSURE CLAMP MECHANISMS ARE LOCATED ON CROSSTUBE SUPPORTS.
- 14) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.
- 15) TORQUE CLAMPS 80 TO 100 IN-LB. ENSURE AT LEAST 1.5 THREADS ARE SHOWING IN SAFETY AND THAT NUT HAS NOT BOTTOMED-OUT AFTER TORQUING.

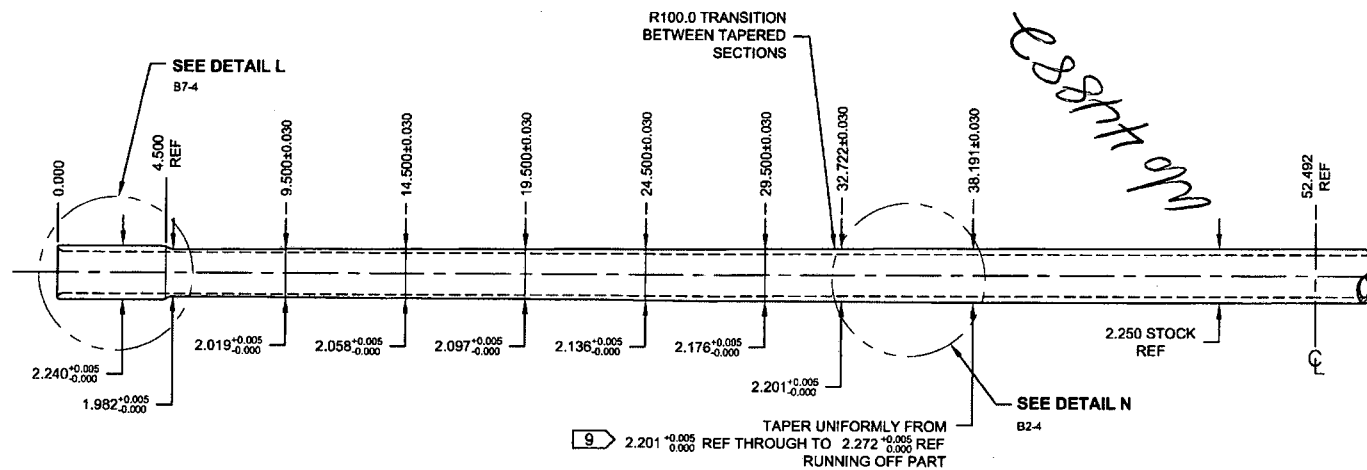
RELEASED
08/11/06

C	REVISE GENERAL NOTES/PART LIST (ZN D7-1); REORGANIZED VIEWS AND REFORMATTED DRAWING TO CURRENT STANDARDS. D3595-063-395 WAS D2856-400-694 (ZN D6-2 & A5-2); REMOVED REF. & ADD TOLERANCE (ZN D3-3, C4-3, C5-3); RELOCATED FLAG #6 (ZN A8-3) PER NCR 210; MOVED TURNING DETAIL & UPDATED TOLERANCE TO SHEET 4.	RF	08.11.06
B	ADD HOLES AND NUT PLATES FOR COMPATABILITY WITH BHT/AA SKUDTUBES	PH	05.07.26
A	NEW ISSUE	CP	00.11.17
REV.	DESCRIPTION	BY	DATE
DESIGN	92	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF	DRAWING NO.	REV. C
CHECKED	RF	D206-667-143	SHEET 1 OF 4
MFG. APPR.	RF	TITLE	SCALE
APPROVED	RF	CROSSTUBE ASS'Y (206L HIGH FWD)	NTS
DE APPR.	RF	COPYRIGHT © 2000 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DATE	08.11.06		

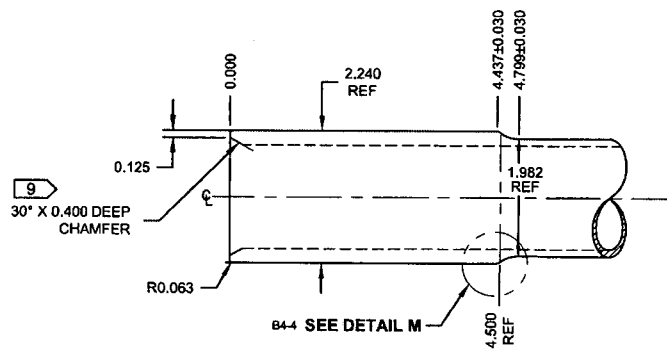


DESIGN	9	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	8	DRAWING NO.	REV. C
MFG. APPR.	8	D206-667-143	SHEET 2 OF 4
APPROVED	4	TITLE	SCALE
DE APPR.	4	CROSSTUBE ASS'Y (206L HIGH FWD)	NTS
DATE	08.11.06	COPYRIGHT © 2000 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

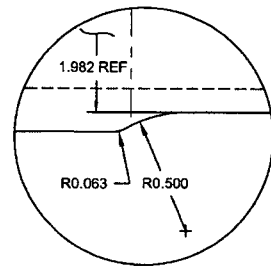




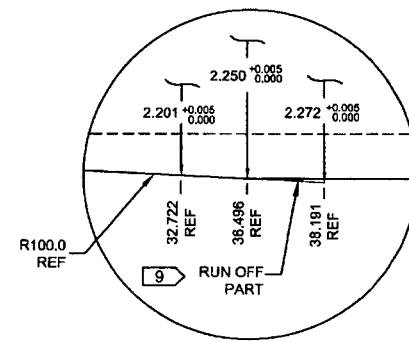
TURNING DETAIL



DETAIL L:
D7-4 **CROSTUBE CUFF**
NOT TO SCALE



DETAIL M:
A6-4 **CUFF TRANSITION**
NOT TO SCALE



DETAIL N:
C4-4 **TAPER RUN-OFF**
NOT TO SCALE

RELEASED

DESIGN	9	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	9	DRAWING NO.	REV. C
MFG. APPR.	9	D206-667-143	SHEET 4 OF 4
APPROVED	9	TITLE	SCALE
DE APPR.	9	CROSTUBE ASS'Y (206L HIGH FWD)	NTS
DATE	08.11.06	COPYRIGHT © 2000 BY DART AEROSPACE LTD	
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DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS IIN-D206-667 REV. C
AND INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D206-667 REV. 2

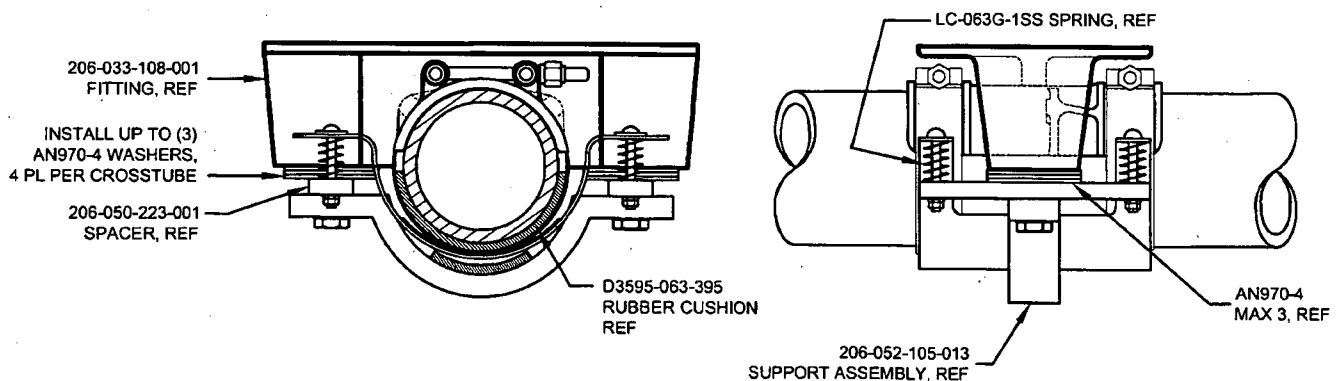
REF CANADIAN STC: SH01-5
REF FAA STC: SR01304NY
REF EASA STC: EASA.IM.R.S.01179

PROBLEM:

FOR D206-667-103 CROSSTUBES (206L FWD) AT CHG 003 AND SUBSEQUENT (SEE DSI 9415) PROPER INSTALLATION OF THE OEM SUPPORT ASSEMBLIES MAY BE IMPOSSIBLE DUE TO THE ADDITIONAL THICKNESS OF THE DART D3595-063-395 RUBBER CUSHIONS. THE 206-052-105-013 SUPPORT ASSEMBLY (OR EQUIVALENT) MAY SIT TOO HIGH RELATIVE TO THE 206-033-108-001 FITTING, CAUSING THE LC-063G-1SS SPRING (OR EQUIVALENT) TO BE OVERLY COMPRESSED.

SOLUTION:

IT IS ACCEPTABLE TO LOWER THE SUPPORT ASSEMBLY BY INSTALLING UP TO QTY (3) AN970-4 WASHERS BETWEEN THE 206-033-108-001 FITTING (OR EQUIVALENT) AND THE 206-050-223-001 SPACER (OR EQUIVALENT). SEE FIGURE BELOW FOR REFERENCE.



CROSSTUBE SECTION: SUPPORT DETAIL

PARTS LIST:

THE FOLLOWING PARTS HAVE BEEN INCLUDED WITH D206-667-103 CROSSTUBES AT CHG 004 AND SUBSEQUENT

ITEM	Qty -103	PART NUMBER	DESCRIPTION
60	12	AN970-4	WASHER

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY: *[Signature]*
D. SHEPHERD (DE # 02)

DATE: 08.12.17
CERT. NO.: SH01-5
ISSUE NO.: 3

A	NEW ISSUE	CP	08.12.17
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>q</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	<i>q</i>		
CHECKED	<i>PH</i>	DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9439	SHEET 1 OF 1
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	206L FWD XTUBE SUPPORT MOD.	NTS
DATE	08.12.17	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	